Work Order ID 68448

PRELIMINARY ISSUE

Wednesday, April 13, 2011 2:33:00 PM

Item ID: D4380-29 **Accept** **Setup Start** **Stop**

Revision ID: PRELIM

Item Name: Vent, Center Combination

Start Date: 4/13/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 4/14/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4380	~~PA9~~ A								
100		0.00							
HandThermo	**Memo**	0.00				x2			WL 11/04/13
Hand Finishing Thermoforming	1-Cut Sheet to required Blank size								
105		0.00							
HandThermo	Dry Material					x2			WL 11/04/13
Hand Finishing Thermoforming	**Memo** Dry Sheet as per QSI022 Kydex	0.00							
	Temp: 150°F								
	Time IN: 4:30 AM 11/04/13								
	Time OUT: 7:00 am 11/04/13								

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
Thermoform						x2			DL 11/04/13
Thermoforming Machine	**Memo**	0.00							
	1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA124 using tool DT9749 Dwg Rev: PAG Folio Rev: A								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC						x1	(x1)		DL 11/04/13
Quality Control	**Memo**	0.00							PTO → ~~Last Page~~
	Visuallly inspect part for proper formation and texture								
130	QC8- Inspect parts - second check	0.00							
QC						/			
Quality Control	Memo Qty 1 pa PAG 11/04/14	0.00							

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Required Date: 4/14/2011 **Req'd Qty:** 1.00
Reference:

Accept

Setup Start
Stop

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							
HandThermo	**Memo**	0.00				x1			11/04/14
Hand Finishing Thermoforming	1-Trim to finished dimensions as per Dwg								
150	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00				x1			11/04/14
Quality Control	Complete FAI document								
160	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo** Qty 1 per PAGE 11/4/14	0.00							PO
Quality Control									

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Required Date: 4/14/2011 **Req'd Qty:** 1.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location:_____	0.00							
Packaging	**Memo** Eagle	0.00							
Packaging						5	11/04/14		
180	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control							11/5/14		

POSITIVE RECALL
EFFECTIVE 11-04-13 AUTH
RELEASED DATE 11/05/14

RD2370 CL 11/04/14

RTO →

Picklist Print

Wednesday, April 13, 2011 2:32:58 PM

Work Order ID: 68448

Parent Item: D4380-29

Parent Item Name: Vent, Center Combination

Start Date: 4/13/2011 **Required Date:** 4/14/2011

Start Qty: 1.00 **Required Qty:** 1.00

Comments: Rev. A New Issue. 11/04/04 DL verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3-62015		Purchased	No			100	sf	530.6026	6.9375	6.9375			

6185 KYDEX .080"

Location	Loc Qty	Loc Code
therm	530.602647	
116576	530.602647	

DL 4/04/14

13.8714 sq ft

PTO →

DART AEROSPACE LTD	Work Order:	68448
Description:	Part Number:	D4380-29
Inspection Dwg: D4380-29 Rev: PA 8		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 1/4 "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by:	DL	Date:	11/04/13

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.8"	+/- 0.100	14.75"	✓		TAPE DL-01	
7.0"	+/- 0.100	7.1"	✓		TAPE DL-01	
5.0"	+/- 0.100	5.0"	✓		TAPE DL-01	
4.9"	+/- 0.100	4.9"	✓		TAPE DL-01	
3.7"	+/- 0.100	3.75"	✓		TAPE DL-01	
Ø 4.0"	~~+/- 0.100~~	4.0"	✓		VERN DL-02	
1.175"	Ref.	1.175"	✓		VERN DL-02	

Measured by:	DL	Date:	11/04/13
Audited by:	JP per PA9	Date:	11.04.14
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14

Dart Aerospace Ltd

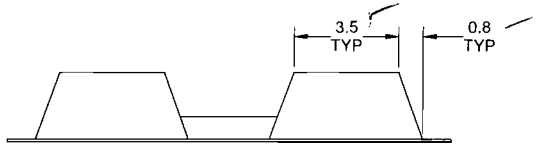
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

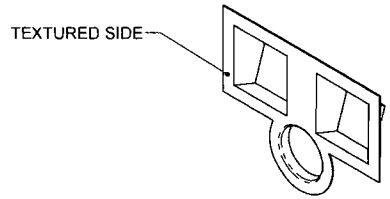
Part No: D4380-29 **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** ✓ **Date:** 11/04/14

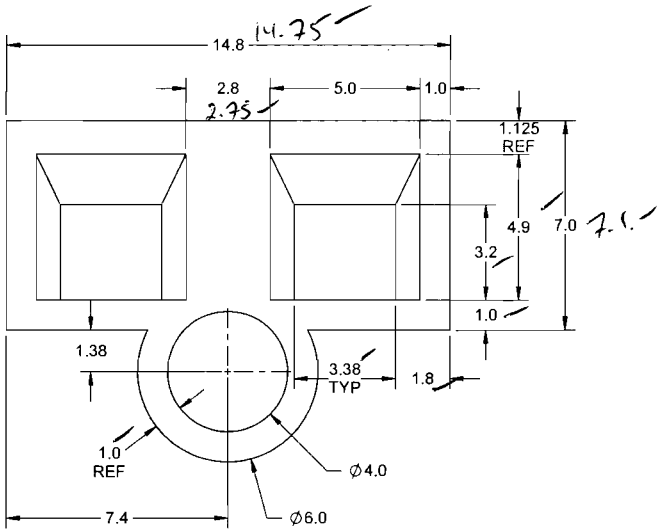
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

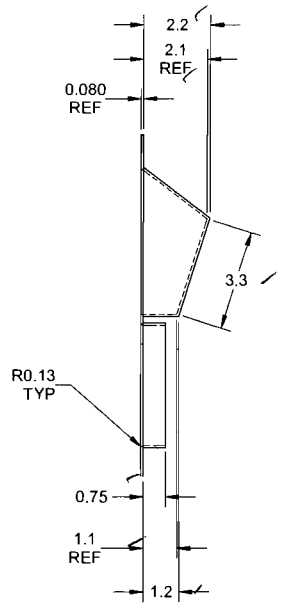
NCR: 68448		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			
11/04/13	120	Webbing between sockets. Re: New product trial run.	[signature]	Scrap & Replace Part. Manually push material while vacuum is applied.	[signature] 11/04/13	✓	[signature]	[signature] 11/04/14

NOTE: Date & initial all entries









D4380-29 VENT, CENTER COMBINATION

6848

NOTES:
1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.47 lbs
8) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040
9) TOOLING: THERMOFORM -29 PART PER MOULD DT9749.
TRIM PER MOULD LEAVING FINISHED EDGE.

PRELIMINARY ISSUE
SC 11.04.05

DESIGN	SC	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	SC	
CHECKED		DRAWING NO. D4380 REV. PA9
MFG. APPR.		SHEET 15 OF 19
APPROVED		TITLE CEILING POCKETS SCALE NTS
DE APPR.		
DATE	11.04.05	

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Dart Aerospace Ltd

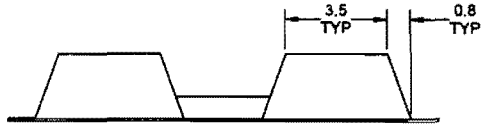
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

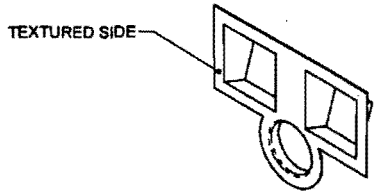
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

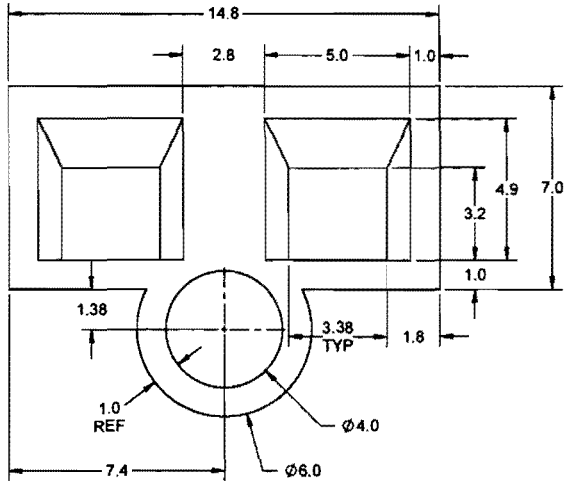
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

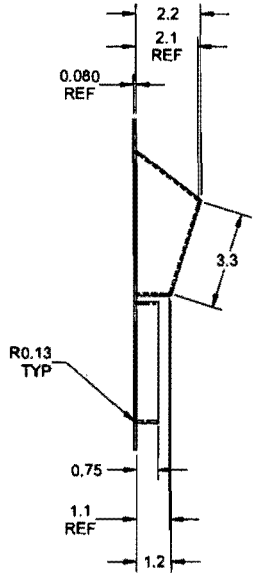
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries









D4380-29 VENT, CENTER COMBINATION

68448

RELEASED
2011 -[illegible]

NOTES:
1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
7) WEIGHT: 0.64 lbs
8) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040
9) TOOLING: THERMOFORM PER MOULD DT9749 AND DART QSI 022
10) TRIM PER MOULD LEAVING FINISHED EDGE
11) MAXIMUM INSIDE RADIUS = 0.188

DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	SC	
CHECKED	[illegible]	DRAWING NO. D4380 REV. A
MFG. APPR.	[illegible]	SHEET 15 OF 19
APPROVED	[illegible]	TITLE CEILING POCKETS SCALE NTS
DE APPR.	[illegible]	
DATE	11.04.21	

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